Dart Aerospace Ltd. Friday, 5/25/2007 8:15:48 AM Kim Johnston **Process Sheet** : SPACER BLOCK **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer Job Number : 32569A : 10251 **Estimate Number** : D3193041 Part Number P.O. Number : NA : D3193 REV C S.O. No. : 4 1 **Drawing Number** : 5/25/2007 This Issue : N/A Prsht Rev. Project Number : C : LANDING GEAR **Drawing Revision** First Issue : N/A : 28517A Material Previous Run : 5/31/2007 Qty: Each **Due Date** Written By Checked & Approved By New Issue 05-11-05 JLM : Est Rev:A Comment Change Rivet Lengh 07-03-19 JLM Est Rev:B **Additional Product** Job Number: Description: Seq. #: 6061-T6 Bar 2.5" x 3.5" 1.0 M6061T6B2500X03500 Comment: Qty.: 0.5156 f(s)/Unit Total: 4.1244 f(s) Material: 6061-T6/T651 (QQ-A-225/8 or QQ-A-200/8) (M6061T6B2.500x03.500) Identify for D3193-1 Batch: 17102838 BAND SAW 2.0 BAND SAW Comment: BAND SAW (8) Cut blanks: 3.500" x 2.500" x 5.900" long Bar HAAS CNC VERTICAL MACHINING #1 3.0 HAAS1 Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per Folio FA374 and Dwg D3193Identify as D3193-1 2-Deburr and Tumble 4.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 5.0 QC8

Comment: SECOND CHECK

(8)

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W/O:		WORK ORDER	CHANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	 A:	Date:	1

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
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NCR:		· <b>\</b>	WORK ORDER NON-CONFORMANCE (NCR)					
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Friday, 5/25/2007 8:15:48 AM Date: Kim Johnston 'User: **Process Sheet** Drawing Name: SPACER BLOCK Customer: CU-DAR001 Dart Helicopters Services Part Number: D3193041 Job Number: 32569A Job Number: Description: Seq. #: Machine Or Operation: HAND FINISHING RESOURCE #1 HAND FINISHING1 60 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 7.0 M105068 Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION 8.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION MS20426AD37 Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s) Pick: Description Batch **Qty Part Number** Rivet 8 MS20426AD3-7 07/09/13 8 NUTPLATE 10.0 MS21073L4 Total: 32.0000 Each(s) Comment: Qty.: 4.0000 Each(s)/Unit Pick: Description Batch **Qty Part Number** Nut Plate M 18728 4 MS21073L4 11.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble D3193-041 as per Dwg D3193 INSPECT WORK TO CURRENT STEP . 12.0 QC5 Comment: INSPECT WORK TO CURRENT STEP \_12. A identify and whack . \_\_\_ >

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Page 2

## **Dart Aerospace Ltd**

W/O:		WORK ORDER	CHANGES				
DATE STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date: <u>6769/19</u>
			QA: N/C Closed:	Date:

NCR:			WORK ORDER NON-CONFORMANCE (NCR)					
		Description of NC		Corrective Action Section B		Verification	Annroyal	Annewal
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NOTE: Date & initial all entries

Date:

Friday, 5/25/2007 8:15:49 AM

'User:

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopter's Services

Drawing Name: SPACER BLOCK

Job Number: 32569A

Part Number: D3193041

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



a 0789-18

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W/O:		WORK ORDER CHANGE	WORK ORDER CHANGES								
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NOTE: Date & initial all entries



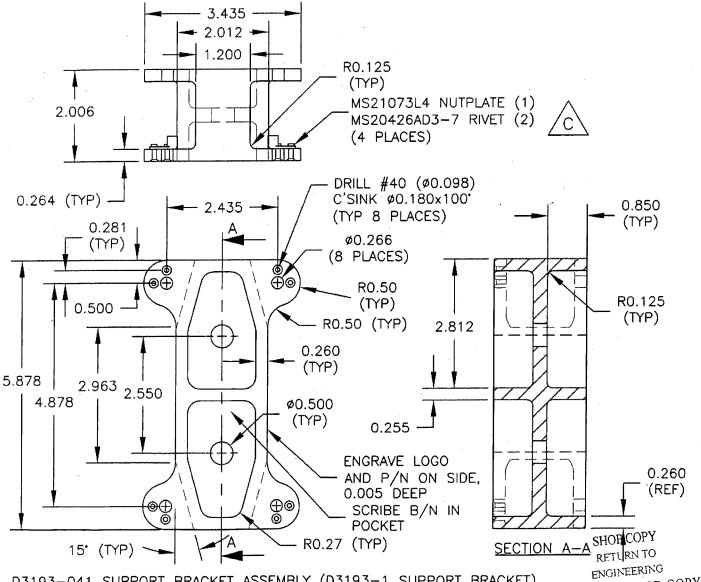
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DESIG	N P	DRAWN BY	DART AEROSPACE LTI HAWKESBURY, ONTARIO, CANADA	)
CHEC	KED	APPROYGD	DRAWING NO.	REV. C
	W	#	D3193 SHE	ET 1 OF 1
DATE			TITLE	SCALE
05.0	09.29		SUPPORT BRACKET ASSEMBLY	1:2
 Α		03.06.09	NEW ISSUE	
R		03 12.22	MANUFACTURED BY DART	

Α	03.06.09	NEW ISSUE
В	03.12.22	MANUFACTURED BY DART
C	05.09.29	MS20426AD3-7 WAS MS20426AD3-5

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE



D3193-041 SUPPORT BRACKET ASSEMBLY (D3193-1 SUPPORT BRACKET)

1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-225/8 OR QQ-A-200/8) (REF DART SPEC. M6061T6B)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.005 TO 0.010

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD	Work Order: 32 569.	5694	
Description: SPACER BLOCK	Part Number: D3193-1		
Inspection Dwg: N3/93 Rev: C	Page 1 of 1		

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

					T	
Drawing	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
Dimension		Dimension			шороснон	
3.435	T. 016	2.435				
2.012	±.010	2.014	<u> </u>			
1.200	±.010	1.200				
2.006	±. 016	2.007				
RO.125	±. DIB	20.130				
0,264	±. 0/0	0.264				
2.435	±. 005	2.435				
0.281	±.005	0.282				
0.500	±.010	0.500				
5.878	±.016	5.879				
4.878	±. 005	4.877				
150	± 1/2°	150				
0.260	±, 010	0.260				
20.50	± 036	RO.500			***************************************	
\$0.266	+ 006	80272				
80.098	± ,004 -,001	80.101				
0.850	±,010	0.850				
RO.125	±.016	R0.125				
2.812	±.010	2.814				
0.255	±. 010	0.255				
0.266	±.016	0.260				- 11-21-
Ø D.180X108	±.010	80.120x120				

Measured by:	and	Audited by:	F	Prototype Approval:	NA
Date:	07/09/03	Date:	67.04.03	Date:	

Rev	Date	Change	Revised by	Approved
А		New Issue	KJ/JLM	